

Work Order ID 62557

Monday, October 04, 2010 10:58:57 AM

Page 1

Item ID: D350-591-214

Accept

Revision ID:

Item Name: Heli-Access-Step, Short RH

Start Date: 10/4/2010 Start Qty: 3.00

Required Date: 10/20/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-04 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

S 12/1/16

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

10.11.04

3 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O
Memo

0.00

0.00

Diolubas

73

P10

130



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod *M108436*
3-Grind End Plate flush *M114877*

0.00

0.00

10.11.05

3

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

3 *Ø* *BE 10/11/09*

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC- Inspect part completeness to step on W/O

ALB Memo

0.00

0.00

S 10/10/07

+3
Rr

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

K 10.11.09

3

of

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

3 10-11-9

W/O: 62557		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/09	120	perm. chang change step #120 from QCS to QCG						
		perm change		10.11.17		10/11/11	10/11/09	
10/11/11	210	QC9 change to QC10, AFT cap is a ground non-structural weld.						
		perm change				10/11/11	10/11/11	

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M108436

5-Grind End Plate flush

*RE 10.11.10**3**Ø*

210



QC

Quality Control

~~QC~~ Inspect visual per QSI004- Fusion Welds

0.00

QC 10

Memo

0.00

*3**Ø**8E10/11/11**PTO**previous
page.
←*

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC Inspect part completeness to step on W/O

0.00



QC

Quality Control

QC 095
Memo

0.00

8 10 11 11

x3
RH

Ph

230

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

20 10 11 11

V3 1/2

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

M 115291

Memo

START TIME: 10:35
OVEN TEMPERATURE: 320°
FINISH TIME: 11:05

0.00

BLH 10-11-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/4/09	# 220	Person. change change step 220 QCS to QCC					S. Kates	
		N/A 10-11-11						

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Wing Walk as per dwg QSI005 4.4 Batch 1115790

0.00



HandFinish

Memo

Hand Finishing

260

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

270

Pick Kit

0.00



Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	8 10/11/10			<div>(83/24)</div>			
290  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-591-214 Location: <u>80</u> PPP Rev: <u>2</u>	0.00 0.00	<div>10/11/10 SP (37)</div>						
300  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	<div>10/11/17</div>						

ME
10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, October 04, 2010 10:59:01 AM



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 525

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------



1210.11.04

128

[REDACTED]

3

38

72

3

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

D3066-1 Manufactured No

200

Each

83.0000

2

6



Spacer

Location

Loc Qty

Loc Code

WA ~~362224~~ 362662 83
60194 35
61205 48



10.11.10

MS20600-AD4W4 Purchased No

200

Each

1,699.000

16

48



Rivets

Location

Loc Qty

Loc Code

ST321 1699
113368 62
114181 11
114718 2
115573 624
115640 1000



10.11.10

D3065-041 Manufactured No

200

Each

53.0000

1

3



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA 362224 53
60200 14
61216 39



10.11.10

D3067-1 Manufactured No

200

Each

72.0000

1

3



End Plate

Location

Loc Qty

Loc Code

WA 362144 72
60141 72



10.11.10

Monday, October 04, 2010 10:59:01 AM

Shop Packet Print

Page 2

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Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

AN4-16A

Purchased

No

270

Each

276.0000

4

12



Bolt



10/11/10 SD

Location

Loc Qty

Loc Code

ST360

276

115016

21

115159

50

115374

105

115422

100

12

D2732

Manufactured

No

270

f

227.6657

1

3



Rubber Extrusion



10/11/10 SD

Location

Loc Qty

Loc Code

ST412

227.665737

43118

2.5

56516

225.165737

✓

Cut 3.00" long, qty 4

AN3-35A

Purchased

No

270

Each

90.0000

2

6



Bolt



10/11/10 SD M115936

Location

Loc Qty

Loc Code

ST353

90

115108

40

115457

50

18

AN4-11A

Purchased

No

270

Each

420.0000

6



Bolt



10/11/10 SD (30)

Location

Loc Qty

Loc Code

ST357

420

110382

220

115316

200

18

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Start Qty: 3.00

Required Qty: 3.00

AN960JD416 NAS1149D0463J Purchased No

270

Each

24.0000

12 36



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

D2230-3 Manufactured No

270

Each

70.0000

2 6



Plug

Location

Loc Qty

Loc Code

ST476

70

55452

2

60846

68

D2856-400 Manufactured No

270

f

276.3760

0.6 1.8



Abraison Strip

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920

213.12

cut 7.20" long, qty 1

MS21042L3

Purchased No

270

Each

1,720.000

2 6



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

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Required Date: 10/20/2010


Start Qty: 3.00

Required Qty: 3.00

AN4-13A Purchased No 270 Each 480.0000 4 12

 Bolt


M116075 10/11/10

Location Loc Qty Loc Code
 ST358 480
 115159 480

D2230-1 Manufactured No 270 Each 87.0000 2

 Lug

B62665 10/11/10

Location Loc Qty Loc Code
 ST476 87
 60289 27
 61713 60

MS21042L4 Purchased No 270 Each 4,434.000 6

 Nut

10/11/10

Location Loc Qty Loc Code
 ST300 4434
 113422 68
 114523 8
 114718 16
 114784 32
 115108 1310
 115589 1900
 115621 1100

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:59:01 AM

Page 6

Work Order ID: 62557

Parent Item: D350-591-214



Parent Item Name: Heli-Access-Step, Short RH

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

AN960JD10

NAS1149D0363J Purchased

No

270

Each

8.0000

4

12



Washer



1115622 10/11/10 38

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

Monday, October 04, 2010 10:59:01 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

SHOP COPY
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E
UNCONTROLLED
SUBJECT
V
W
NO. *62537*
0110-10-04

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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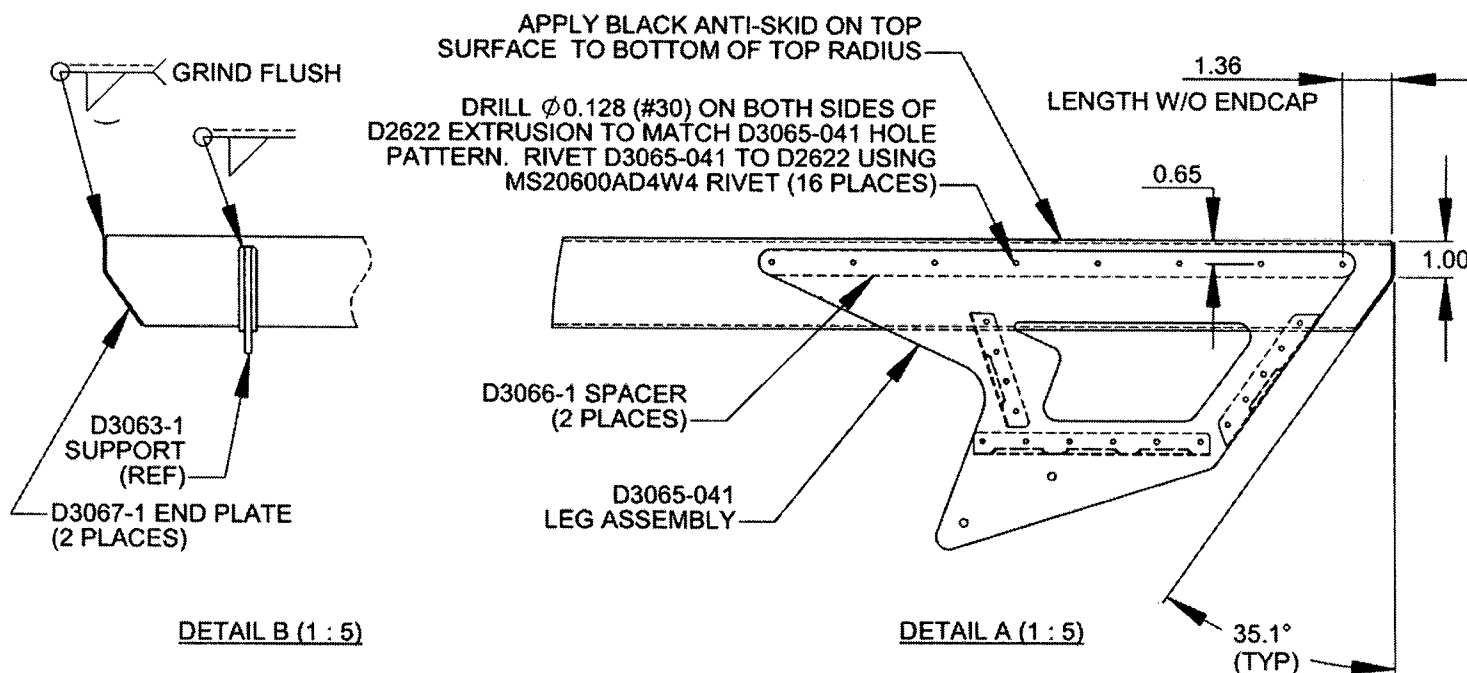
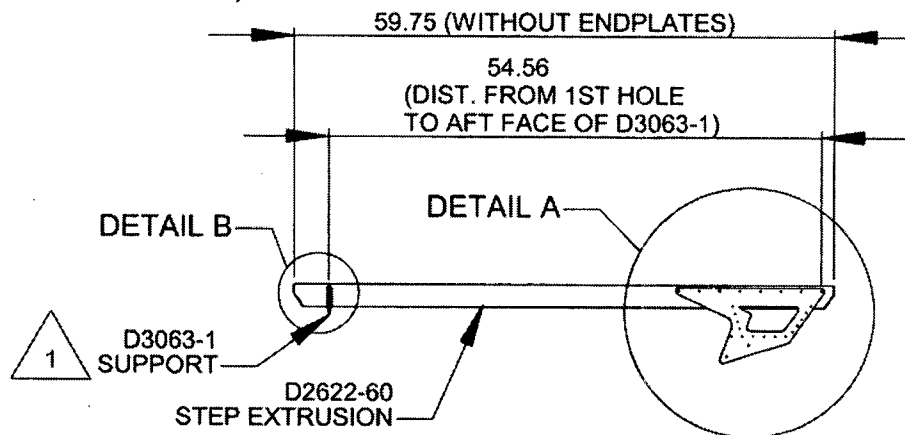
W/62557

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. A
02.09.11		SHEET 2 OF 2
TITLE	DRAWING NO.	SCALE
STEP ASSEMBLY, HI SHORT	D3078	1:20

RELEASED
02.09.2011



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G

Date: 08.10.06

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.


For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:



ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

REFERENCE ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A DSI 9472 SHEET 1 OF 2 TITLE SCALE BOLT ADDITION NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE 09.08.05			